

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018210**Date Inspected:** 04-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower bays**Summary of Items Observed:**

On this day CALTRANS Office of Structural Materials (OSM) Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

TOWER BAY 10

This QA observed ZPMC qualified welding personnel identified as 2023443 perform Shielded Metal Arc Welding (SMAW) on Tower Lift 5, run off tabs. The weld joint is identified as WSD1-TL5-4B/F-67B. ZPMC QC Mr. Zaho Mao Mao was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3111-B-U4C.

TOWER BAY 11

This QA observed ZPMC qualified welding personnel identified as 057180 perform Flux Core Arc Welding (FCAW) on Bike Path. The weld joint is identified as BK004A1-025-043. ZPMC QC Mr. Li Peng Fei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-TC-P4F.

This QA observed ZPMC qualified welding personnel identified as 040312 perform Flux Core Arc Welding (FCAW) on Bike Path. The weld joint is identified as BK004A2-027-016. ZPMC QC Mr. Li Peng Fei was present

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to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-L1b.

This QA observed ZPMC qualified welding personnel identified as 061938 perform Shielded Metal Arc Welding (SMAW) on lift 5 Tower cover plates. The weld joint is identified as NSD1-TL5-3B-F. ZPMC QC Mr. Li Peng Fei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3111-B-U4C.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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